

Work Order ID 94687

\*94687\*

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Item ID: D3847-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: WEARPAD

Start Date: 12/14/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-20-12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	B								
100		0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3847								
304, 1063	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

(8)

B13-1-12

(8)

B13-1-12

# Work Order ID 94687

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Item ID: D3847-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: WEARPAD  
 Start Date: 12/14/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 1/11/13 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 15 2-89 13.7.14				8			
130 <b>*130*</b> Brake NC Brake NC	Memo Form as per dwg	0.00 0.00				8			SN 13/01/14
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 DAS 15 2-89 13.7.14				8			

**\*94687\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/14/12      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 1/11/13      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

**\*150\***

0.00

### Large Fab

## Memo

Weld hardcoat as per dwg  
A/R 2059B Batch: m124170

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

0.00

QC

## Memo

## Quality Control

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

0.00

QC

## Memo

## Quality Control

**\*94687\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/14/12      **Start Qty:** 6.00

\*6\*

**Cust Item ID:**

**Required Date:** 1/11/13      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

## Set Up/ Run Hours

[illegible]

180

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

**\*180\***

## Memo

0.00

Powdercoat

## Powder Coating

190

QC3- Inspect Part Finish

0.00

**\*190\***

## Memo

0.00

QC

## Quality Control

200

Identify as per dwg & Stock Location: FF-001 0.00

0.00

\*200\*

## Memo

0.00

### Packaging

## Packaging

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: WEARPAD

Start Date: 12/14/12 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

13-01-30

# Picklist Print

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Page 1

Work Order ID: 94687

Parent Item: D3847-1

Parent Item Name: WEARPAD

Start Date: 12/14/12

Required Date: 1/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	220.2560	0.1236	0.7806318	6.5	12/13-1-12	

Location

Loc Qty

Loc Code

MAT020

220.256

122245

13.156

123136

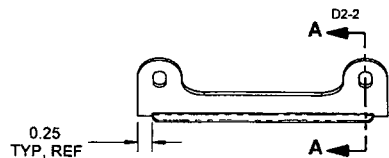
207.1

122248

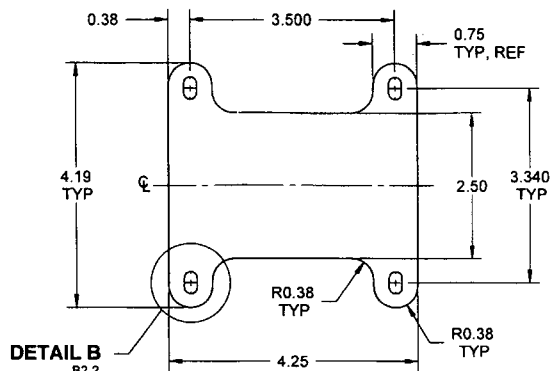
8



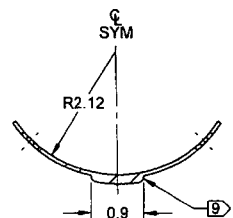
8 7 6 5 4 3 2 1



**D3847-1 WEARPAD**  
MADE FROM D3847-1F FLAT PATTERN

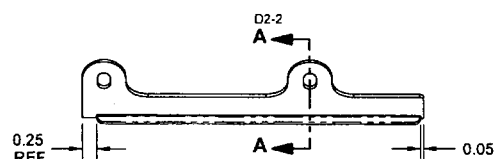


**D3847-1F FLAT PATTERN**

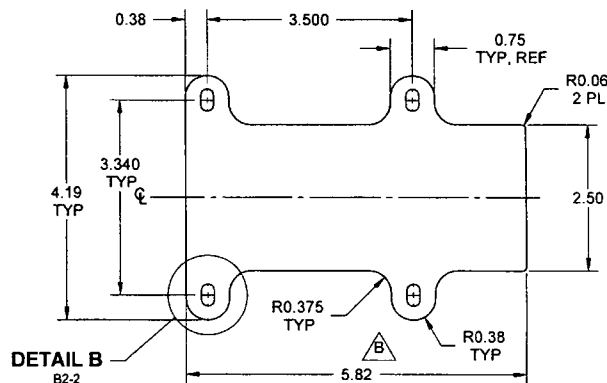


**SECTION A-A** D7-2 B7-2

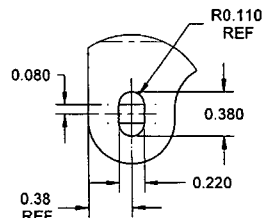
94687  
PL 12-20-12



**D3847-11 WEARPAD**  
MADE FROM D3847-11F FLAT PATTERN



**D3847-11F FLAT PATTERN**






**DETAIL B** C5-2 B5-2  
TYP, SCALE 2X

RELEASED  
12/20/12

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:  
D3847-1 = 0.03 lbs  
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3847	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1